<b>Work Ord</b> November-30-12					Page 1						
Item ID: Revision ID: Item Name:	D3917-3 Washer			Accept	*N90004010  Cust Item ID: Customer:			<b>)*</b> s	Setup Star	1 71	S1* S2*
Start Date: Required Date: Reference:	11/30/12 : 12/14/12	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*								
Approvals:			Date: 12-12-03 Tooling:  Date: SPC (Y/N):		Date:			F	tun Star Sto		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3917	Α										
100 *100* Hardinge				0.00				6	\$		DAS 13 8-89
Hardinge CNC Lath	ne Small	<b>Memo</b> TURN AS FOLIO RE DWG REV	PER FOLIO FA876 & V:	DWG	- 1-8				·		
110		DEBURR  QC2- Inspect parts off n	nachine FAI/FAIB	0.00					/		•
*110*					17-1-5	_		6	$\phi$		DA

0.00

Memo

Quality Control

											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-O	100	VFORM	MANCE / UPDAT	ΓE	·	· · · · · ·	
											QA Closed:	Date:	
Work Orde						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	۲۰.				<del></del>	Rework	1		Skid-tube C	rosstube		Water Jet	Engineering
Part N	No.					Scrap	1		<b>⊢</b>	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		~ <b></b>	Finishing	Rec/Stor	e/Packaging	Other
NCR 1	No.				· · · · · · · · · · · · · · · · · · ·	Work Order Update	]		Large Fab Co	omposite		Supplier	
							_						
Root				Į	l	ption of work order update	1	Initial nief Eng	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance			Description	on	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			Ī										
Operator													
Material													
Setup												:	
Other			1										
Process			ļ										
Supplier			Ì										
Training					1								
Unapproved				1									
						F	AUI	LT CATE	GORY				
Landi	ng (	Gear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
1		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Uncl	ear	Part Lost/M	ssing	Wrong Stock Pulled
	F-1 F-1			Contamination		Maintenance			Part Moved	_	<del>-</del>		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Work Order ID 94137 Page 2 November-30-12 9:27:46 AM D3917-3 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Washer Item Name: Start Otv: 6.00 Start Date: 11/30/12 Cust Item ID: Required Date: 12/14/12 **Rea'd Oty:** 6.00 **Customer:** Reference: Run Process Plan: **Tooling:** Date: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Code Qty Otv Number Stamp **Run Hours** 120 0.00 OC8- Inspect parts - second check OAC \*120\* D.a 13/01/08 QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 072 130 \*120\* Packaging 0.00 Memo Packaging 13/1/10 to MK 01-09 140 OC21- Final Inspection - Work Order Release 0.00 \*140\* OC 0.00 Memo Quality Control

											DQA:	Dat	e: _		
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE									
											QA (	Closed:	Dat	e:	
Work Ord	or.					DISPOSITION				AGAINST DE	PART	MENT	PROCESS		
Work Ord	CI.					Rework	]		Skid-tube	Crosstube	Water Jet				Engineering
Part	No.					Scrap			Machining	Small Fab	1		d. Eng. Coor.		Quality
						Use-as-is			noforming	Finishing	R	ec/Stor	e/Packaging	_	Other
NCR	No.					Work Order Update	]		Large Fab	Composite	_		Supplier	Ш	
Root					Descri	ption of work order update		Initial Action		tion	Si	gn &			
Cause		Date				Ch	ief Eng	Desc	ription		ate	Verification	,	QC Inspector	
Doc/Data															
Equip/Tooling															
Operator		1								1		1			
Material															
Setup															
Other															
Process			1											j	
Supplier					ĺ							•			
Training															
Unapproved							<u> </u>								
						F.	AUL	T CATE	GORY						
Land	ing (	3ear			_	General		•			٦		ŗ		•
	L	Bending				Bend		Grain		L	Oval	ized			Pressure/Forced
	Centre Not Concentric to O/S BC					BOM/Route	L	Hardwa	re		Ove	r/Under	tolerance		Temperature/Cure
Cracks				Broken/Damaged		Inspecti	on incomplete		Part	Incorre	ct		Weld		
1 2	$\perp$	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Part	Lost/M	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part	Moved			-
		Heat Trea	at			Countersink		Mislabe	led		Posi	tioned V	Vrong		-
1	Inspection Strip in Tube				Cut Too Short Misread			Pow	er Loss/	Surge		Other			

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

## **Picklist Print**

November-30-12 9:27:46 AM

Work Order ID:

94137

Parent Item:

D3917-3

Parent Item Name:

Washer

**Start Date:** 11/30/12

Required Date: 12/14/12

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD

IPP Rev:B as per dwg REV.A DD

40.487

93.327

	10.02.22 verified	by:EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"		Purchased	No			100	f	207.3570	0.02	0.1263158	}		
Denni Round Bar 0.73				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT055		207.357							
				116	5183	2.4						*	
				117	7273	1.555						_	_
				[ 113	7322	0.94				<del></del> \1	1 -5	- 1 -	γ '
				12	1783	68.648				214	17	1	0

122582

123698

Page 1

											DQA:	Date	:	
NCR:	Yes	/ No	•			WORK ORDER NON-C	100	<b>NFORM</b>	MANCE / UPDATE		·			
											QA Closed:	Date	:	
Work Order:						DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
						· L	•							
Root					Descri	ption of work order update		Initial	Action	Action				
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Doc/Data	L			ŀ										
Equip/Tooling									•					
Operator	<u> </u>		1			·								
Material														
Setup	<u> </u>											,		
Other	<u> </u>				į									
Process	-			<u>'</u>										
Supplier	⊢													
Training	H													
Unapproved		<u> </u>	1		<u> </u>	<b>.</b>	<u> </u>	T CATE	GOPV			<u> </u>		
Landi	na (	Gear			<u> </u>	General	AUL	LICATE	GONT					
		Bending				Bend	Г	Grain			Ovalized	. Г	Pressure/Forced	
	一	1 -	nt Concei	ntric to		BOM/Route	$\vdash$	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Centre Not Concentric to O/S Cracks			Broken/Damaged	$\vdash$	4	ion Incomplete		Part Incorre	<b> -</b>	Weld			
	$\vdash$	Crushed/	Crimped			Burrs	H	4 '	ions Incomplete/Unclear		Part Lost/M	<b>⊢</b>	Wrong Stock Pulled	
	$\vdash$	Cuffs	- · · · · · · · · · · · · · · ·	•		Contamination		Mainte	•		Part Moved			
İ	<u> </u>	Heat Trea	nt			Countersink		Mislabe			Positioned Wrong			
1	Inspection Strip in Tube			<b>-</b>	Cut Too Short	-	Microso			Power Loss	Other			

Offset

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Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	94137
Description: Washer	Part Number:	D3917-3
Inspection Dwg: D3917 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST												
	X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments					
Ø0.65	+/-0.030	-623-			27-6	1 les						
0.06	+0.000/-0.020	.052					,					
Ø0.257	+0.006/-0.001	,257			/							
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Measured by:		Audited by:	D.A	তিতি	Prototype A	proval:	N/A					
Date: /	3-1-8	Date:	13/01/0	8-89		Date:	N/A					
Rev Date C	hange				Revis	ed bv∧	Apprøved					
A 10.04.01 No	ew Issue				KJ	90	4					

